

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013932**Date Inspected:** 12-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**TRIAL ASSEMBLY YARD****ULTRASONIC INSPECTION****OBG SEGMENT 8AE**

ABF Report No: UT-8E-046

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Weld identification numbers were.

SEG044A-045 (8AE, S.P to B.P- Bike path side)

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of planar transverse indication.

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No relevant indications were observed.

### ULTRASONIC INSPECTION

#### OBG SEGMENT 7EE

ABF Request No: 05112010-2

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Rejectable indications were observed. Inspection was carried out on repair areas. Weld identification numbers were.

CA052-002, 006 (7EE, D.P to E.P- Bike path side)

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of planar transverse indication. For more information refer the ABF /CT report dated on 05/12/2010.

### ULTRASONIC INSPECTION

#### OBG SEGMENT 8AE

ABF Report No: UT-8E-045

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Weld identification numbers were.

SEG044A-044 (8AE, S.P to B.P- Cross beam side)

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of planar transverse indication.

No relevant indications were observed.

### TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

#### OBG SEGMENT 7AW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing Flux Cored Arc Welding process for weld OBW7N-003 located on PCMK. Counter weight connection plate. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-1.

#### OBG SEGMENT 7EW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067876 performing Flux Cored Arc

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Welding process for weld SP443-001-025 located on PCMK. Hold back weld between “T” stiffener and side panel (cross beam side). ZPMC QC Mr. Cai Xiao Feng monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232.

This QA Inspector observed ABF QA Inspector performing Ultrasonic inspection on the weld between edge panel and deck panel (cross beam side).

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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